



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

5109808

D407-667-105
Job Sheet 180863



Part No: D407-667-105

Job Qty: 1 ea

Part Name: Fwd Crosstube - High 407



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 7/17/18

Job Tracking No:

Due Date: 8/15/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG DSI9565 REV A, DSI9628 REV A, D407-667-145 REV C (DEO) IPP Rev:F 05.09.01 Add holes for comp. w/ Bell Skids KJ/JLM IPP Rev:G 08-05-16 chg QC6 to QC15 DD ver:EC IPP Rev:H 08-06-03 update per DSI9415 (ECN1198) DD ver:ec IPP Rev:I 08-07-14 add (scribe inside of tube) seq.6 DD ver:EC IPP Rev:J 08-07-28 update per (par 08-013) DD ver:EC IPP Rev K 09.01.06 ECN 08-562 EC ver:DD IPP REV:L 11.08.05 PER ECN 11-615 DD VER:EC IPP REV:M 12.08.20 DSI9628 revA (ECN12-631) DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	8/15/18	8/15/18	0.00	0.00	Start Up Stores/Pkg-1		SP 2018-09-13
110	Packaging	1 pcs	8/15/18	8/15/18	0.00	0.00	Packaging1-4		GP 2018-09-13
120	CNC Bend Crosstubes	1 pcs	8/15/18	8/15/18	3.77	2.50	CNC Bend Crosstube		GP 2018-09-13
130	QC	1 pcs	8/15/18	8/15/18	0.00	0.00	QC15		38
140	Crosstubes	1 pcs	8/15/18	8/15/18	0.00	1.28	Crosstubes-2		GP 2018-09-13
150	HandFXtube	1 pcs	8/15/18	8/15/18	0.00	0.36	HandFinish5		GP 2018-09-13
160	QC	1 pcs	8/15/18	8/15/18	0.00	0.00	QC5		9-89 DAS
170	QC	1 pcs	8/15/18	8/15/18	0.00	0.00	QC7-3		28
180	Outsource	1 pcs	8/15/18	8/15/18			SKY002-VC		OK OCT 0 1 2018
190	Packaging	1 pcs	8/15/18	8/15/18	0.00	0.00	Packaging2		25 OCT 0 2 2018
200	QC	1 pcs	8/15/18	8/15/18	0.00	0.00	QC6		38
210	SprayPaint	1 pcs	8/15/18	8/15/18	0.00	0.25	Spray Paint		27 18-10-18
220	QC	1 pcs	8/15/18	8/15/18	0.00	0.00	QC14		12 18-10-22
230	Crosstubes	1 pcs	8/15/18	8/15/18	0.00	1.52	Crosstubes-2		SA 18-10-22
240	QC	1 pcs	8/15/18	8/15/18	0.00	0.00	QC5		28
250	Packaging	1 pcs	8/15/18	8/15/18	0.00	0.00	Packaging1-4		OCT 2 3 2018
260	QC	1 pcs	8/15/18	8/15/18	0.00	0.00	QC4		69 DAS OCT 2 6 2018
265	DC	1 pcs	8/15/18	8/15/18	0.00	0.00	DC		9-89 DAS OCT 2 6 2018
270	Packaging	1 pcs	8/15/18	8/15/18	0.00	0.00	Packaging3-2		69 OCT 2 6 2018
280	QC21-FG	1 Ea	8/15/18	8/15/18	0.00	0.00	QC21		9-89 DAS OCT 2 6 2018

Part Op 120 - Bend tube as per Dwg D407-667-145 using CNC bender program 407-fw

Descriptions: 140 - ***** ENSURE PROPER JIG POSITIONING BEFORE DRILLING***** , VERIFIED BY: 21 OCT 2 6 2018
holes & ream using drill Jig DT8541 & DT8542 as per Dwg D407-667-145. Drill all (3) top holes. Holes facing inboard. 2- Drill Fwd rivet holes using drill Jig DT8787 fwd as per Dwg D407-667-145. 3- C'sink holes as per Dwg D407-667-145. Allow rivet to sit below surface to compensate for paint. 4- Flip tube and switch drilling Jigs from right to left, left to right. Locate Jigs off existing holes using "T" pins. Drill ONLY 2 top holes. ONLY plug most bottom holes to prevent accidental drilling. 5- Drill holes and ream using drill Jig DT8541 & DT8542 as per Dwg D407-667-145. Drill only the top (2) holes. 6- Drill Aft rivet holes using drill Jig DT8787 aft as per Dwg D407-667-145. 7- C'sink holes as per Dwg D407-667-145. Allow rivet to sit below surface to compensate for paint. 8- Scribe part # and batch # using vibrating stylus as per Dwg D407-667-145 9- *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE*** Deburr & Inspect for surface damage.
Repair damage within limits as per Dwg D407-667-145
150 - ***IMMEDIATELY AFTER GRINDING***

180 - *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE*** OUTSIDE SERVICE -CROSSTUBES Liquid Penetrant Inspection as per QSI 038 Or Level 2 Attach copy of NDT results to work order
190 - *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE*** Inspect for transit damage
200 - *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE*** Inspect for damage & ensure results are as per Dwg D206-667-145
210 - *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE*** MASK AREA PRIOR TO PAINTING AS PER DWG AND DEO*** PRIME BATCH: 138877 PAINT BATCH: 138956
220 - Then, Wrap in plastic bag to protect from scratches
230 - 2-Install supports with Proseal 890 per D407-667-145 (DEO) and QSI 015 3-Install supports clamps Using Dt9565 as per Dwg D407-667-145 (DEO), Torque to 80-100 IN-LBS. 4-Install nut plates as per Dwg D407-667-145. Touch-up rivet heads with Imron paint. Proseal 5096394 exp 3/9 Sikaflex 138787 exp 12/18
240 - ***RE-CHECK TORCQUE ON CLAMP AFTER PROSEAL HAS CURED FOR 72HOURS AS PER DWG.***
265 - Photocopy bluefile and create labels as per PPP D407-667-105 CHG005
270 - Identify and pack for shipping as per PPP D407-667-105 Location : FG097

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D407-667-105TRN	Crosstube Turning Detail 5085082	1 Ea (1 ea)	90-Start up Operation	
D206-667-017	Grounding Strap	1 Ea (1 ea)	230-Crosstubes	
D2873-043	Nut Plate Assembly	2 Ea (2 ea)	230-Crosstubes	
D2873-045	Nut Plate Assembly	2 Ea (2 ea)	230-Crosstubes	
D2891-1	Support 2.25	2 Ea (2 ea)	230-Crosstubes	
D3595-063-395	Rubber Cushion 0.63" Wide X 3.95" Long	4 Ea (4 ea)	230-Crosstubes	
MS20601-AD4W10	Rivet	14 Ea (14 ea)	230-Crosstubes	
MS21920-20	Clamp	4 Ea (4 ea)	230-Crosstubes	
AN5-10A	Bolt	10 Ea (10 ea)	250-Packaging	5054109
AN5-30A	Bolt	4 Ea (4 ea)	250-Packaging	5019375X2 505691X2
AN5-32A	Bolt	4 Ea (4 ea)	250-Packaging	5058983
MS21042L5	Nut	4 Ea (4 ea)	250-Packaging	5093592
NAS1149D0563J	Washer	18 Ea (18 ea)	250-Packaging	5093773X16 5050053X2

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D407-667-105TRN	1	5	0
230-Crosstubes	D206-667-017 5049001	1	13	0
	D2873-043 5090584	2	117	0
	D2873-045 5050682	2	23	0
	D2891-1 5077442	2	20	0
	D3595-063-395 5033983	4	143	0
	MS20601-AD4W10 5019432	14	305	0
	MS21920-20 5034404	4	148	0
250-Packaging	AN5-10A	10	207	0
	AN5-30A	4	36	0
	AN5-32A	4	378	0
	MS21042L5	4	856	0
	NAS1149D0563J	18	1,555	0

Part Specifications

Specifications could not be found.

Plex 7/17/18 12:56 PM Dart.lajeunesse.marie



Container No: S109808



Part: D407-667-105

Job No: 180863

Serial No/Batch: S109808

Revision: D/D

Inspector:

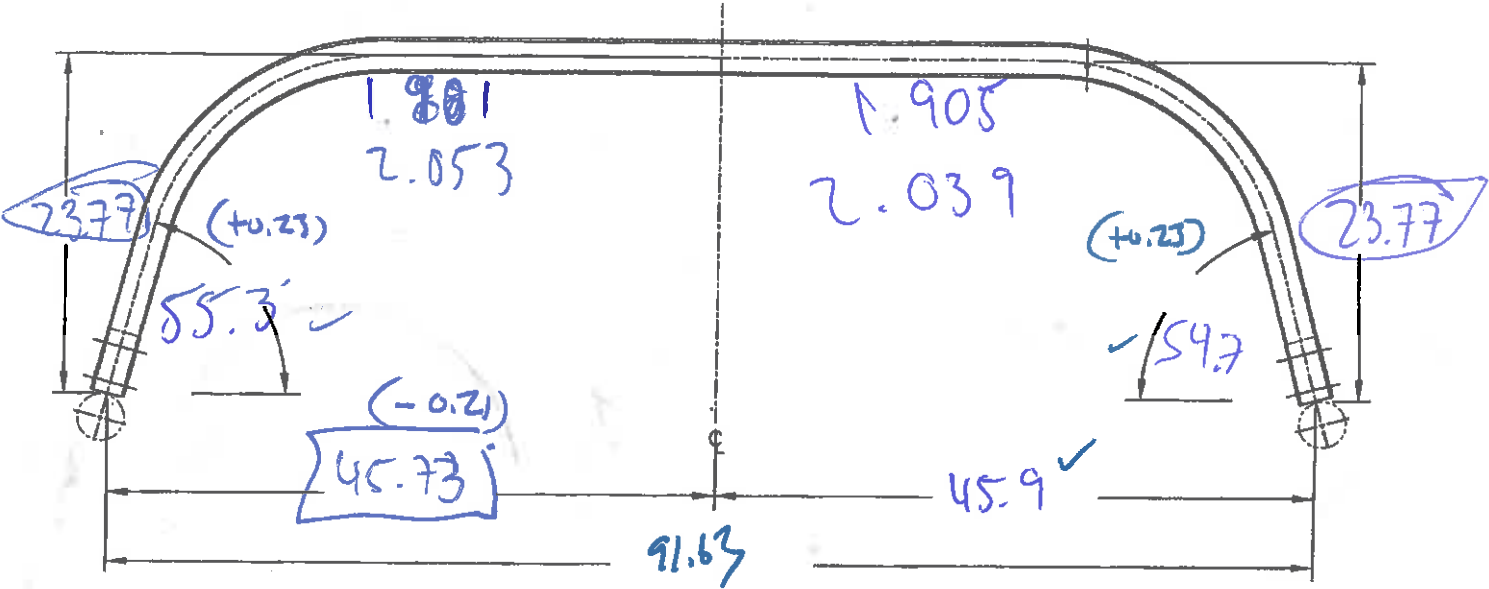
Exp Date:

Instructions: TC STC SH01-5 Issue 3, FAA STC SR01304NY 05/12/15, JCAB JAI

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CANADA
TEL: 1 813 832-6200
Email: sales@dartaero.com
www.dartaerospace.com

DART AEROSPACE LTD	Work Order:	180863
Description: Crosstube High Fwd (407)	Part Number:	D407-667-105
Inspection Dwg: D407-667-145 Rev: C		Page 1 of 1

Required Dimension	Min	Max
Height	23.41	23.67
1/2 Span	45.81	46.07
Angle	54	56
Total Span	91.62	92.14
Bending Passes	6	--
Crushing	--	6%



	Side A	Side B
Bending Passes	12	16
Crushing	3.8%	3.4%
Comments		

QC15 Inspection	
Date	

Rev	Date	Change	Revised by	Approved
A	07.02.06	New Issue	KJ/JM	
B	09.11.12	Dimensions updated per Dwg Rev C	KJ	
C	12.04.16	Added bending, crushing dimensions	KJ	
D	12.10.30	Revised Total Span dimensions & Dwg Rev	KJ	

Item	Qty	Part Number	Description
1	-145		
1	X	D407-667-145	CROSSTUBE ASSEMBLY (407 HIGH FWD)
2	1	D6010-115	CROSSTUBE
3	2	D2873-043	NUT PLATE
4	2	D2873-045	NUT PLATE
5	2	D2891-1	SUPPORT
6	4	D3595-063-395	RUBBER CUSHION
7	4	MS21920-20	CLAMP (OR MS21920-21)
8	14	MS20801AD4W10	RIVET (OR NAS9302B-4-10)
9	A/R	MAGNOBOND 6398	ROCKWELL SPECIFICATION RBO-120-023 ADHESIVE (TEXTRON/BELL SPEC. 299-947-100, TYPE II, CLASS 2 ADHESIVE)

GENERAL NOTES:

- 1) MATERIAL: MANUFACTURED FROM D6010-115
FINISHED LENGTH = 113.20+0.020
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART QSI 005 4.2
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED.
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
- 6) IDENTIFICATION: SCRIBE DART PART NUMBER "D407-667-145" AND BATCH NUMBER ON INSIDE OF CLIFF USING VIBRATING STYLUS.
- 7) WEIGHT: 17.8 lbs
- 8) PART IS SYMMETRIC ABOUT CENTERLINE
- 9) RUN CUTTER OFF PART WHERE INDICATED. BLEND OUT EDGE LONGITUDINALLY, TRANSITION SHOULD BE SMOOTH.
- 10) BEND PROGRESSIVELY WITH A MINIMUM OF 9 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- 11) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- 12) INSTALL D2891-1 SUPPORT USING 0.03" TO 0.06" THICK LAYER OF MAGNOBOND 6398 PER QSI 015. LET CURE FOR 12 HOURS AFTER INSTALLATION AND PRIOR TO PACKAGING.
- 13) INSTALL MS21920-20 CLAMPS (OR -21) WITH D3595-063-395 RUBBER CUSHIONS TO SECURE THE D2891-1 SUPPORT ON TOP SIDE OF THE CROSSTUBE. ENSURE CLAMP MECHANISMS ARE LOCATED ON CROSSTUBE SUPPORTS.
- 14) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 15) TORQUE CLAMPS 80 TO 100 IN.-LB. ENSURE AT LEAST 1.5 THREADS ARE SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING.

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 180863
11/5
1807-19

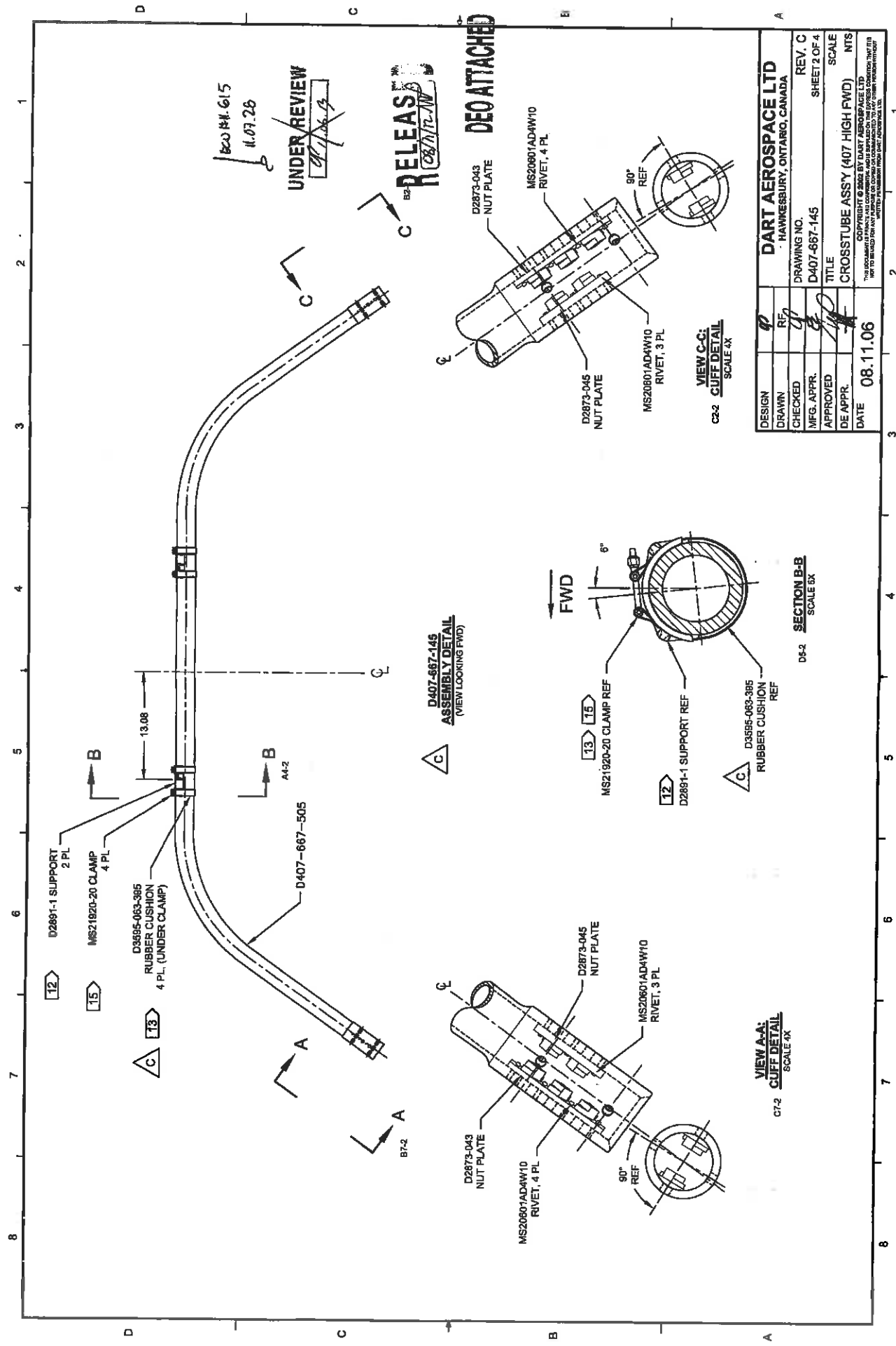
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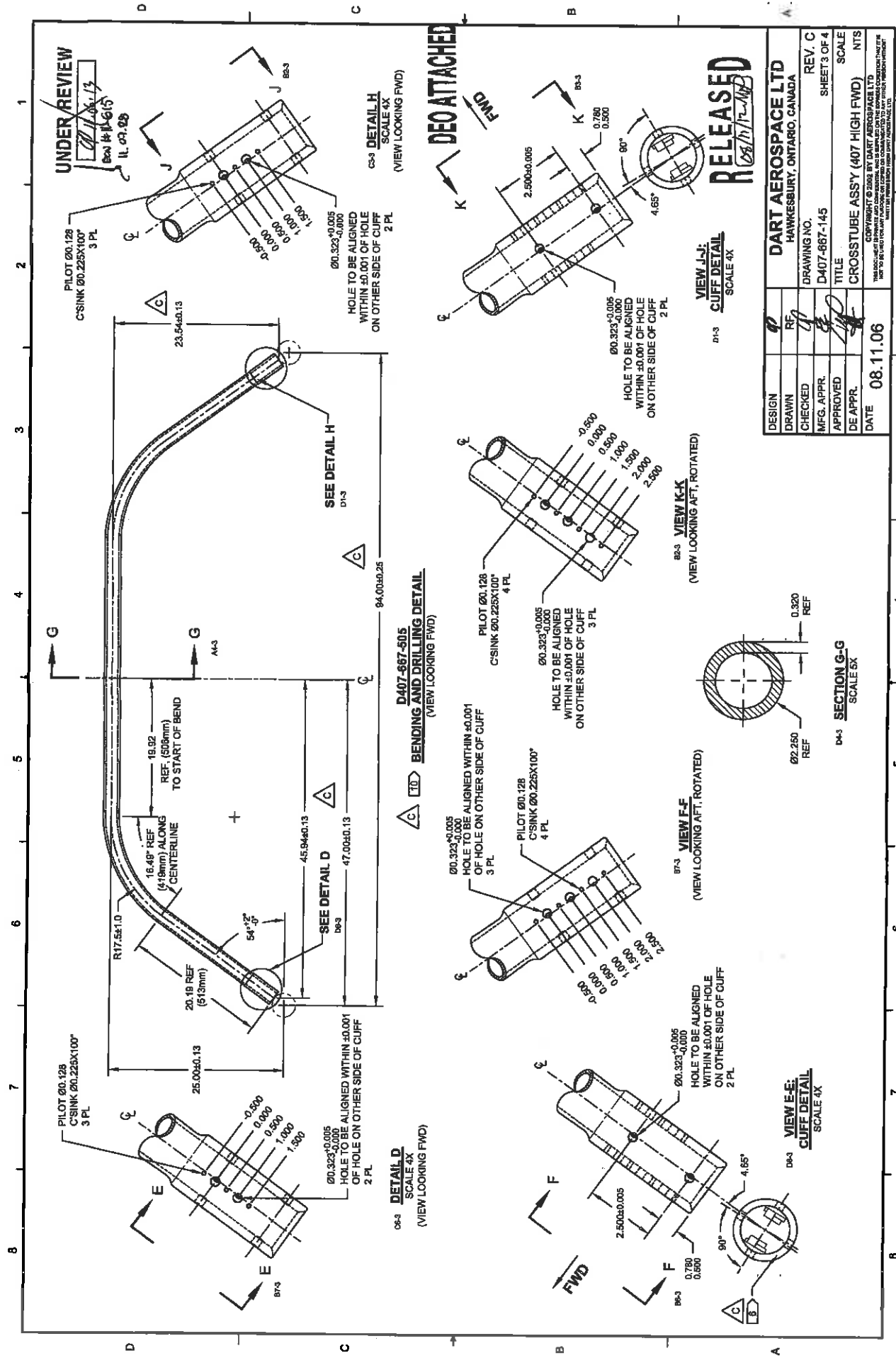
PCW #11-615
11.07.26

UNDER REVIEW

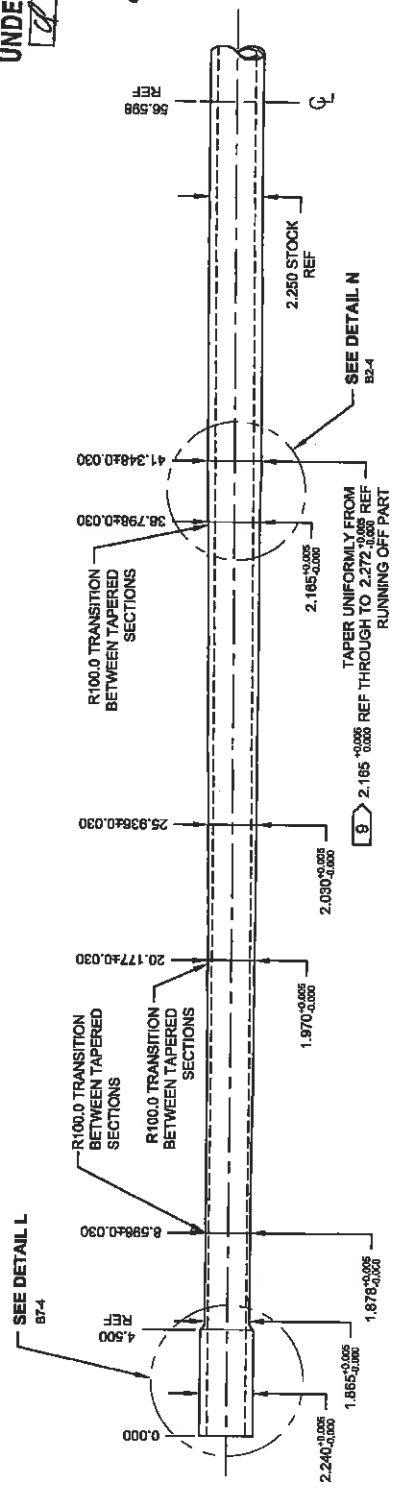
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R 08/11/12

C	REVISE GENERAL NOTES/PART LIST (ZN D7-1): REORGANIZED VIEWS AND REFORMATTED DRAWING TO CURRENT STANDARDS. D2895-063-395 WAS D2886-400-894 (ZN D6-2 & A5-2); DE-MOVED REF. 7 ADD TOLERANCES (ZN D6-3, C4-3, D6-3) RELOCATED FLAG #6 (ZN A6-3) PER NCR 210; MADE 1 TURNING DETAIL & UPDATED TOLERANCE TO SHEET 4.	RF	08.11.06
B	ADD HOLES AND NUT PLATES FOR COMPATABILITY WITH BHTAA SKIDTUBES	PH	06.07.28
A	NEW ISSUE	CP	02.05.08
DESIGN	DESCRIPTION	BY	DATE
DRAWN	RF		
CHECKED	qf		
MFG. APPR.	D407-667-145		
APPROVED	TJP		
DE APPR.			
DATE	08.11.06		
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		REV. C	
DRAWING NO.		SHEET 1 OF 4	
TITLE		SCALE	
CROSSTUBE ASSY (407 HIGH FWD)		NTS	
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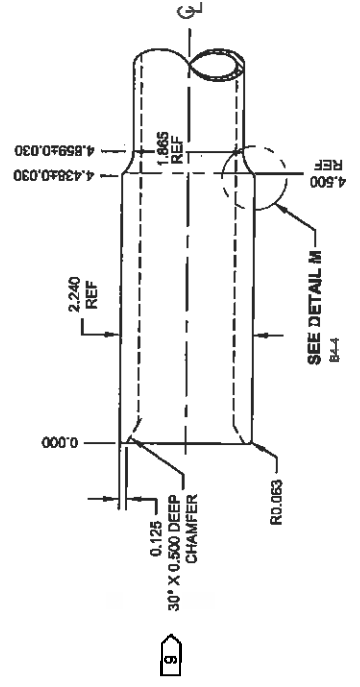
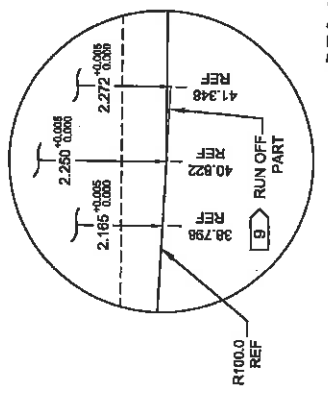




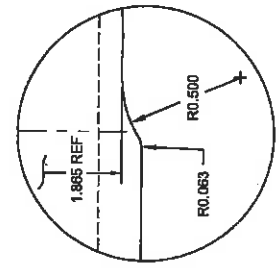
UNDER REVIEW
08/11/06
08/11/06
1.07.26



TURNING DETAIL



**DETAIL L:
CROSSTUBE CUFF**
NOT TO SCALE



**DETAIL M:
CUFF TRANSITION**
NOT TO SCALE

**DETAILED
RELEASED**
DETAIL N:
TAPER RUN-OFF
NOT TO SCALE
C3-4

DESIGN	07	DART AEROSPACE LTD
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA
CHECKED	07	DRAWING NO.
MFG. APPR.	07	D407-667-145
APPROVED	07	TITLE
DE APPR.	07	CROSSTUBE ASSY (407 HIGH FWD)
DATE	08.11.06	SCALE
		NTS

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DRAWING NO. D407-667-145	TITLE CROSSTUBE ASS'Y (407 HIGH FWD)	REV. C	DART AEROSPACE LTD		D.E.O. NO. D407-667-145-C-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN 90	CHECKED JSS		ENGINEERING ORDER	MFG. APPR. JAD	APPROVED	DE APPR. JAD	
DATE 11.07.15	DATE 11.07.22		DATE 11.07.22	DATE 11.07.22	DATE 11.07.22	DATE 11.07.21	

PURPOSE:
REPLACE MAGNOBOND WITH PROSEAL.

CHANGE:

IS:

Item	Qty	Part Number	Description
9	A/R	PROSEAL 890 B-2	SEALANT, AMS-S-8802 CLASS B-2

WAS:

9	A/R	MAGNOBOND 6398	ROCKWELL SPECIFICATION RBO-120-023 ADHESIVE (TEXTRON/BELL SPEC. 299-947-100, TYPE II, CLASS 2 ADHESIVE)
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NOTE 12 & 15, SHEET 1 IS AMENDED AS FOLLOWS:

IS:

12) TO INSTALL D2891-1 SUPPORT: ABRASE MATING SURFACE OF SUPPORT AND CROSSTUBE WITH 180-GRIT SANDPAPER AND REMOVE RESIDUE WITH MEK (OR EQUIVALENT). APPLY A 0.04" TO 0.07" THICK LAYER OF PROSEAL 890 CLASS B-2 (OR AMS-S-8802 CLASS B-2) SEALANT TO MATING SURFACE OF SUPPORT.

15) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING. PRIOR TO PACKAGING, RE-CHECK TORQUE ON CLAMPS AFTER PROSEAL 890 SEALANT HAS CURED FOR 72 HOURS.

WAS:

12) INSTALL D2891-1 SUPPORT USING 0.03" TO 0.06" THICK LAYER OF MAGNOBOND 6398 PER QSI 015. LET CURE FOR 12 HOURS AFTER INSTALLATION AND PRIOR TO PACKAGING.

15) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING.

RELEASED
2011-07-28
WJD

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DRAWING NO.	TITLE	REV. C	DART AEROSPACE LTD	D.E.O. NO.	SHEET NO.	SCALE
D407-667-145	CROSSTUBE ASS'Y (407 HIGH FWD)		ENGINEERING ORDER	D407-667-145-C-2	SHEET 1 OF 1	NTS
DRAWN	AJS	CHECKED	MFG. APPR.	APPROVED	DE APPR.	
DATE	12.08.02	DATE	12.08.02	DATE	12.08.02	

PURPOSE:

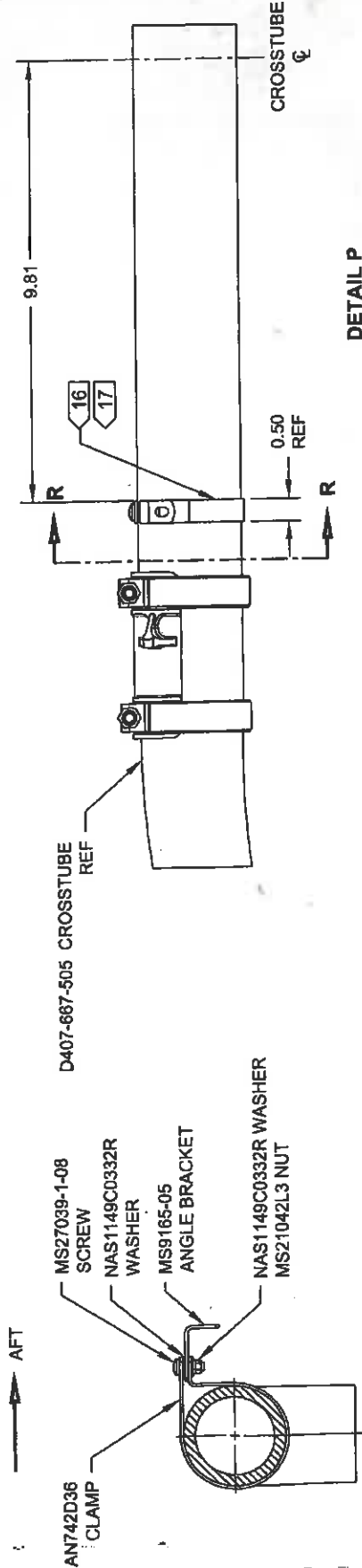
ADD ELECTRICAL GROUNDING STRAP

CHANGE:

ITEM	QTY	PART NUMBER	DESCRIPTION
1	X	D407-667-145	CROSSTUBE ASSEMBLY (407 HIGH FWD)
10	2	AN742D36	CLAMP
11	2	MS9165-05	ANGLE BRACKET
12	2	MS21042L3	NUT (OR MS21042-3)
13	2	MS27039-1-08	SCREW
14	4	NAS1149C0332R	WASHER (OR AN960C10L)

GENERAL NOTES:

- 16) MASK AREA UNDER CLAMP PRIOR TO PAINTING
- 17) SEAL EDGES WHERE AN742D36 CLAMP MEETS WITH THE CROSSTUBE USING SIKAFLEX-241/-291 OR MIL-S-8802 CLASS B2 OR PROSEAL 890 SEALANT
- 18) PERFORM RESISTANCE CHECK TO ENSURE MAX RESISTANCE IS 10 MILLIOHMS



SECTION R-R

DETAIL P
BONDING STRAP INSTALLATION 2 PL

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Tel (613) 632-5200

PURCHASE ORDER
PO041148

Supplier: SKY002-VC
Skyservice
6120 Midfield Road
Mississauga
ON
L5P 1B1 Canada
Phone: 905-678-5636
Fax: 905-678-5841

PO No: PO041148
PO Date: 9/26/18
Due Date: 9/28/18
Purchase Order
Revision:
Revision Date:
Ship-To Contact: Tsimiklis, ChrisoulaPhone:

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground
Pymt Terms: Net 30
Freight Terms:
Special Comments:

Items												
Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price	
1	180863	D407-667-105	Fwd Crosstube - High 407 : TC STC SH01-5 Issue 3, FAA STC SR01304NY 05/12/15, JCAB JAPAN STC- 32-OSA 02/02/28, EASA STC EASA.IM.R.S.01179 06/07/03, BRAZIL 2009S08-16 09/08/25, BRAZIL 2009S08-17 09/08/25 *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE*** OUTSIDE SERVICE -CROSSTUBES Liquid Penetrant Inspection as per QSI 038 Or Level 2 Attach copy of NDT results to work order	Firmed	-	9/28/18	1 pcs	0 pcs	1 pcs	\$121.00/pcs	\$121.00	
	180861	1 X	OCT 0 2 2018	Firmed	-	9/28/18	1 pcs	0 pcs	1 pcs	\$121.00/pcs	\$121.00	
	180864	1 X	OCT 0 2 2018	Firmed	-	10/5/18	1 pcs	0 pcs	1 pcs	\$121.00/pcs	\$121.00	
Sub Total:							3	0	3		\$363.00	
2	182865	D212-664-101	Fwd Crosstube - High : TC STC SH01-9 Issue 3, FAA STC SR01298NY 09/01/08, EASA STC EASA.IM.R.S.01304 07/03/06, DGAC MEXICO STC IA- 316/2015 15/06/17 *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE*** Liquid Penetrant Inspection as per QSI 038 LPI as per ASTM 1417 Level 2 Attach copy of NDT results to work order	Firmed	-	9/28/18	1 pcs	0 pcs	1 pcs	\$121.00/pcs	\$121.00	
	182864	1 X	OCT 0 2 2018	Firmed	-	9/28/18	1 pcs	0 pcs	1 pcs	\$121.00/pcs	\$121.00	
	182867	1 X	OCT 0 2 2018	Firmed	-	9/28/18	1 pcs	0 pcs	1 pcs	\$121.00/pcs	\$121.00	



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER
PO041148

Items											
Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
182866			OCT 0 2 2018	Firmed	-	10/5/18	1 pcs	0 pcs	1 pcs	\$121.00/pcs	\$121.00
Sub Total:							4	0	4		\$484.00
3	180148	D119-796-141	Fwd Crosstube Installation Without Step (No Hardware) : TC STC SH14-45-Issue 1, FAA STC SR03504NY 15/01/28, EASA STC 10052022 Revision 1 15/02/13, DGCA INDIA LoA 07-09/2011-AED (Part) 15/07/16, BRAZIL STC 2015S07-16 15/07/30, CAAP PHILIPPINES LoA 16/05/11, CHINA VSTC0757 16/07/22, RUSSIA STC CT316-A119 16/08/11, DGAC INDONESIA STC SR025 18/02/19 *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE*** Liquid Penetrant Inspection as per QSI 038Or Issue P/O: LPI as per ASTM 1417 Level 2 Attach copy of NDT results to work order	Firmed	-	9/28/18	1 pcs	0 pcs	1 pcs	\$121.00/pcs	\$121.00
4	182055	D130-1048-241	EC130 Aft Crosstube *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE*** Liquid Penetrant Inspection as per QSI 038 LPI as per ASTM 1417 Level 2 Attach copy of NDT results to work order	Firmed	-	9/28/18	1 pcs	0 pcs	1 pcs	\$121.00/pcs	\$121.00
182060			OCT 0 2 2018	Firmed	-	9/28/18	1 pcs	0 pcs	1 pcs	\$121.00/pcs	\$121.00
Sub Total:							2	0	2		\$242.00
Grand Total:										\$1,210.00	



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada
Tel (613) 632-5200

PURCHASE ORDER
PO041148

Order Notes

Procurement Quality Clauses

- A005 right of entry
- A012 chemical and physical test report
- A016 personnel qualification
- A017 raw material identification (as applicable)

- A022 Apical Processing
- A024 process certifications
- A026 certification of material conformance

- A041 quality management system
- A042 dart notification by supplier
- A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 10/2/18 10:17 AM dart.tsimikitis.chrisoula

 skyservice		Work Order Traveler Sky Service F.B.O. Inc.		TCCA AMO 53-89 / EASA 145.7142 / BDA AMO 385	
10105 Ryan Avenue, Dorval, Quebec, H9P 1A2					
WO #: MVO37590	Customer: Dart Aerospace Ltd.	Dept: NDT YUL	Reference: PO41148 ✓		
Descr:	PN:	S/N:	Qty: 1		
Make:	Model:	Reg:	A/C S/N:		
TSN:	CSN:	TSO:			
Task: UNSCHEDULED			Sequence: 1		

Work Required:

CARRY OUT NDT INSPECTION (LIQUID PENETRANT) ON 10 CROSSTUBES

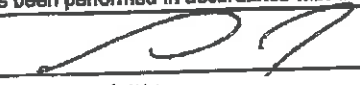
ITEM ID: D119-796-141 FWD CROSSTUBE
 1 - WORK ORDER ID#: 180148 ✓

ITEM ID: D212-664-101 FWD CROSSTUBE - HIGH
 2 - WORK ORDER ID#: 182866 ✓
 3 - WORK ORDER ID#: 182865 ✓
 4 - WORK ORDER ID#: 182864 ✓
 5 - WORK ORDER ID#: 182867 ✓

ITEM ID: D130-1048-241 EC130 AFT CROSSTUBE
 6 - WORK ORDER ID#: 182055 ✓
 7 - WORK ORDER ID#: 182060 ✓

ITEM ID: D407-667-105 FWD CROSSTUBE - HIGH 407
 8 - WORK ORDER ID#: 180861 ✓
 9 - WORK ORDER ID#: 180863 ✓
 10 - WORK ORDER ID#: 180864 ✓

Action Taken:		Date:	Initial/Stamp:
LIQUID PENETRANT INSPECTION CARRIED OUT ON ITEMS LISTED ABOVE (ITEMS 1-10) AS PER ASTM1417M-13 NO CRACK FOUND Pen: ZL-27A MWO5678 DEV: SKD-S2 MPO11715 CLEANER: SKC-S MPO13923		SEP 26 2018	 
Description	Location P/N	Qty	Batch
		S/N Off	S/N On
N/A			

I certified that the maintenance described above has been performed in accordance with the applicable standard of airworthiness.		ACA/SCA Stamp 	Date: SEP 26 2018
Signature:  Name: ANTONINO MARGHERITA			